

Date: Monday, 8/13/2007 10:02:03 AM  
 User: Jean-Luc Menard.

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	DOOR DOUBLER
Job Number	33875		
Estimate Number	12681		
P.O. Number	N/A	Part Number	D3594043
This Issue	8/13/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3594 REV A
First Issue	N/A	Project Number	N/A
Previous Run	33551	Drawing Revision	A
Written By	<u>JLM</u> 07-08-13	Material	N/A
Checked & Approved By		Due Date	8/20/2007
Comment	Est Rev A New Issue 07-01-22 EC	Qty:	30
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.5355 sf(s)/Unit Total : 16.0650 sf(s) 6061-T6 .080 Sheet Batch: M104921		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: A Prog Rev: A		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS PER DWG D3594		

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33875

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



cancel

Comment: INSPECT WORK TO CURRENT STEP

on 07/08/23 (X30)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



cancel

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25

07-08-25

30

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-08-28

9.0 MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Anchor nuts

BATCH: M10404014 X4mx

M105513 (25x)

M105589 (5x)

07/10/31

10.0 MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

BATCH: M10 21

07/10/31

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

07/10/31 (30)

SP

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/06 (430)

cancel

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

POSITIVE RECALL

Identify and Stock

EFFECTIVE 07/08/06 AUTH W

Location: (7/11/08 30)

RELEASED

DATE 07/08/23

Date: Monday, 8/13/2007 10:02:03 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33875

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



3d

Comment: FINAL INSPECTION/W/O RELEASE

17.07.08

Job Completion



U 17.07.08

DART AEROSPACE LTD	Work Order:	33875
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article  Prototype

Measured by:	SAD	Audited by:	CR	Prototype Approval:	N/A
Date:	07/08/13	Date:	07/08/13	Date:	N/A

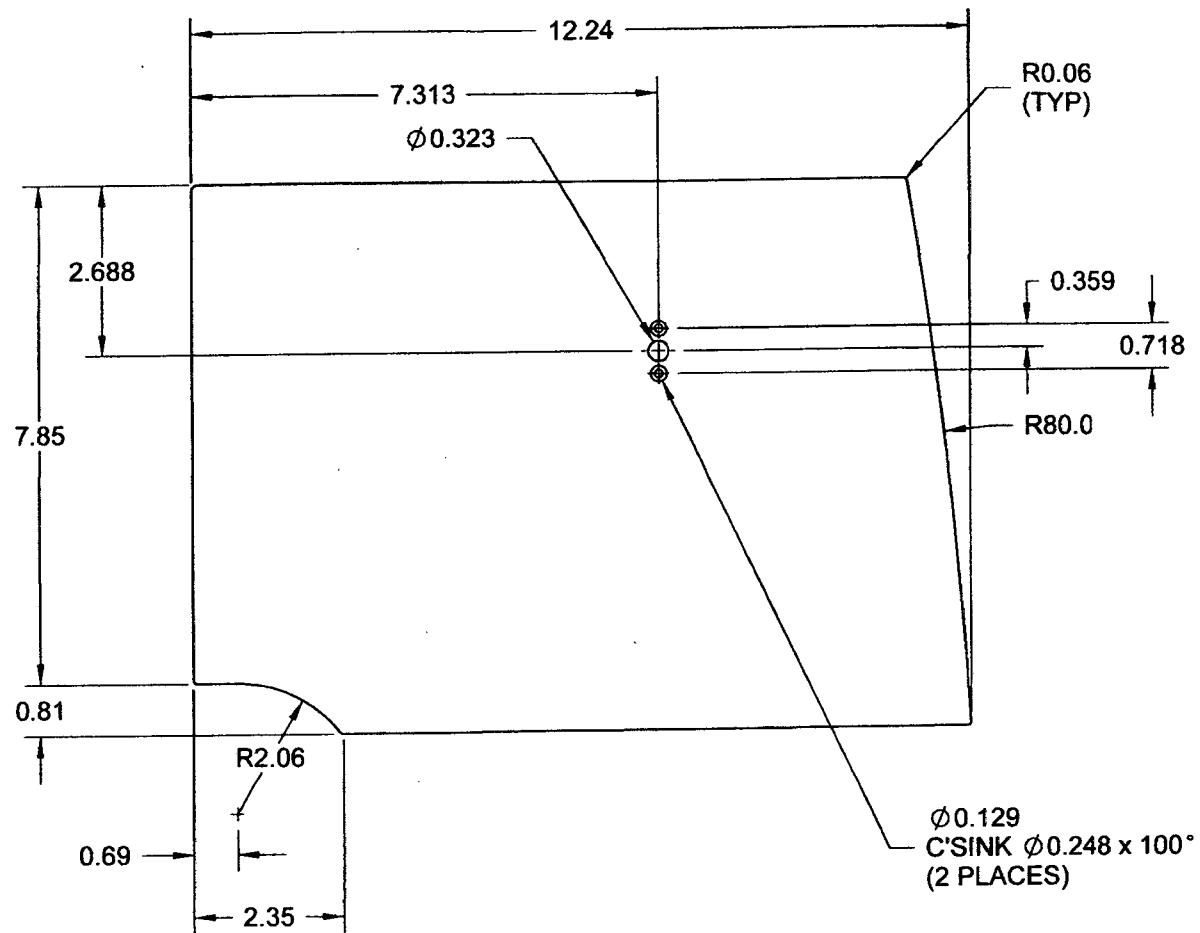
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	P/O D3594-043	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

# DART

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>BS</i>	APPROVED <i>SH</i>	DRAWING NO. D3594	REV. A	SHEET 3 OF 3
DATE 07.04.13	TITLE DOUBLER	SCALE 1:3		

RELEASED  
04.07.11 13

07.07.11 13  
PER 800011001



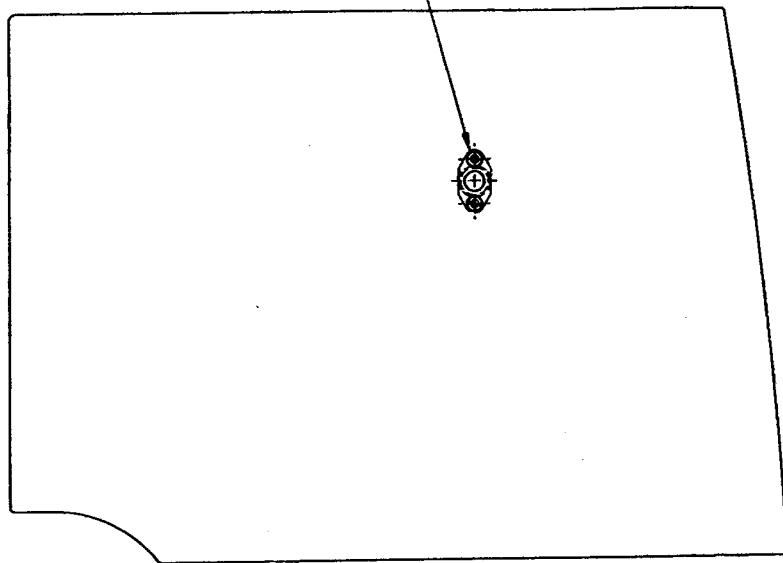
**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3594
DATE	07.04.13	TITLE FLOOR DOUBLER ASSEMBLY SCALE 1:3

**RELEASED**

07.07.11

P&C 800 #109 MS20426AD4-4 RIVET  
(2 PLACES)MS21069-5  
ANCHOR NUTD3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

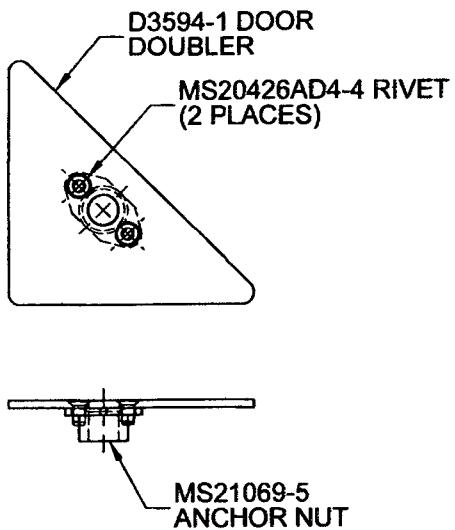
QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

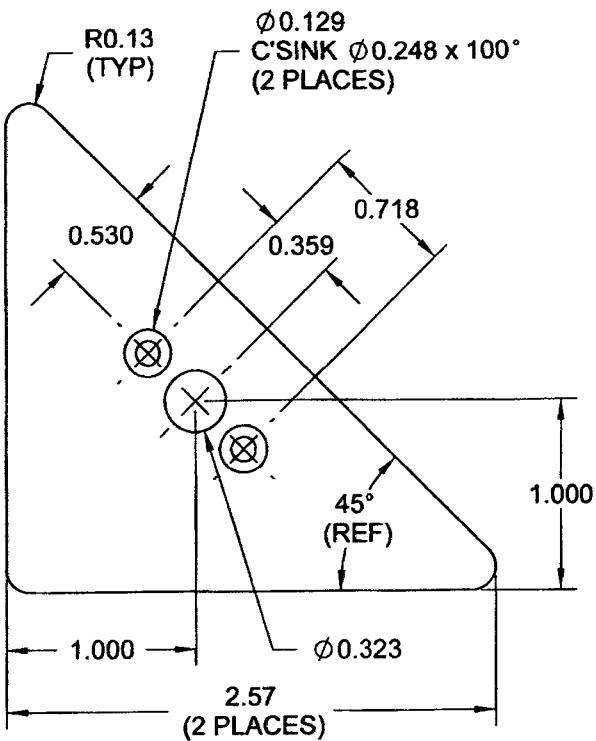
**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3594	REV. A SHEET 1 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**RELEASED**  
07.07.11  
for review

**D3594-041 DOOR DOUBLER ASSEMBLY**  $\triangle$   
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET



**D3594-1 DOOR DOUBLER**  $\triangle$   $\triangle$

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/22	# S.O	2 Parts has 1 hole (each) that was counter sink too deep  R.C. Human error	Initial 08/08/22	Mat. is 6061-T6. fill hole with weld per AS204 and Grind flush AR  using MS 21069-5 nut plate. Transfer drill hole and re-counter sink	07-08-22	07/08/22	✓ 08/08/22	✓ 08/08/22
			L		07-08-22	L	L	L

NOTE: Date & initial all entries